

Date: Tuesday, 10/17/2006 11:21:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 29052	
Estimate Number : 10348	
P.O. Number : N/A	Part Number : D28581
This Issue : 10/17/2006 S.O. No. : N/A	Drawing Number : D2858 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 27127	Material : N/A
Written By : <u> </u>	Due Date : 11/2/2006
Checked & Approved By : <u> </u>	Qty : 24 Um : Each
Comment : Est C 00.06.22 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s)

Material: 1.50" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B15001250)

Batch M101694

Er 06/11/12 x 8 (24)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 6.02"

Note: 1 Blank Makes 3 Parts

Er 06/11/12 x 8 (24)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2858-

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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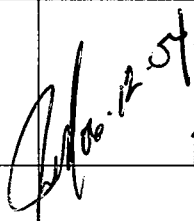
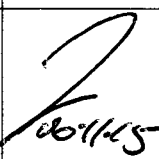
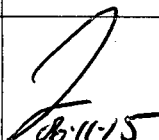
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Er 06/11/13 x 26

Er 06/11/13 x 26

QC2 second check

SA 06.11.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/11/15	40	There should be a QC 8 second check after they are tumbled and deburred between steps 5 and 6. Permanent change	J.G.	06/11/15				
06/11/15	6.0 7.0	Swap steps to have parts inspected before plodding Permanent change as shown	J.G.	06/11/15				

Part No: N/A PAR #: N/A Fault Category: Prod/Machined parts NCR: Yes No DQA: Y Date: 06/12/04
QA: N/C Closed: Y Date: 06.12.05

NCR: <u>29052</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/12	# 3.0	3 parts scrap. Dim. 0.147" is 0.126" (.021") off nominal. First Run. offset was too low.	<i>[Signature]</i>	Scrap / Destroy and Replace Raise offset	Ep 06/11/12	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
06/11/13	# 3.0	1 part scrap. operator error. Made mistake when operating X origin value	<i>[Signature]</i>	Scrap / Destroy and Replace	Ep 06/11/13	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

5.6/5 06/11/13

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

Q.M. 06/11/16

(26)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 06.11.15

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

Q.M. 06/11/30

(26x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU 4/12/01 (26)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 391

PU 4/12/01 (26)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/12/04

Job Completion



C 206112101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

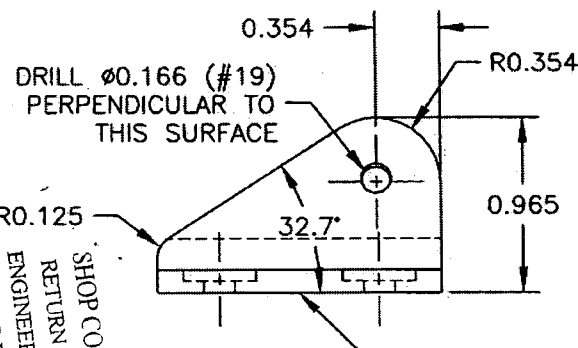
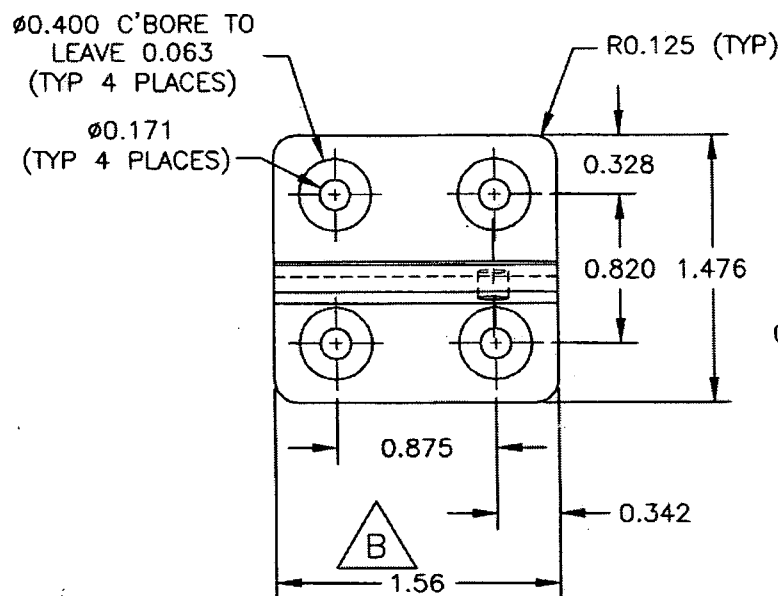
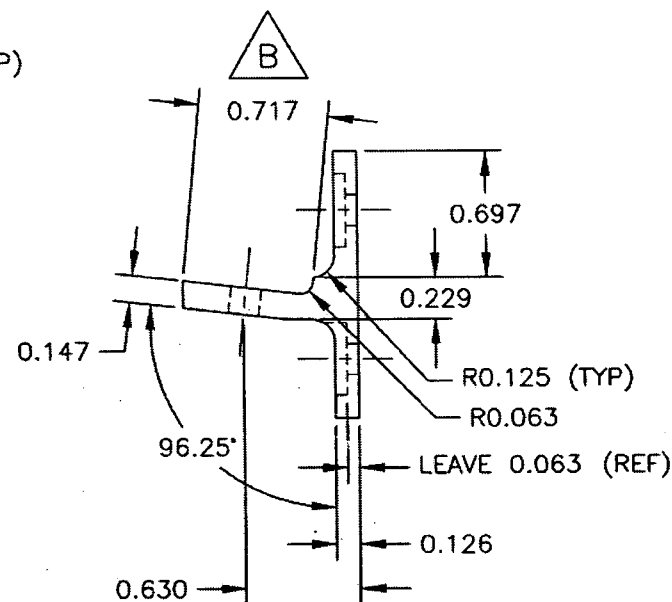
NOTE: Date & initial all entries

DART



RELEASED
99.03.03 KE

DESIGN	WE	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2858
DATE	99.02.28	TITLE	HINGE BRACKET	REV. B
				SHEET 1 OF 1
				SCALE 1:1
	A		98.12.14	NEW ISSUE
	B		99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART AEROSPACE LTD		Work Order:
Description: <i>Hinge Bracket</i>		Part Number: <i>D2858-1</i>
Inspection Dwg: <i>D2858-1 Rev: B</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi 0.171$	± 0.005 -0.001	0.173	✓			
$\phi 0.400$	± 0.006 -0.001	0.400	✓			
0.063	± 0.010	0.060	✓			
R 0.125	± 0.010	0.125	✓			
0.328	± 0.010	0.323	✓			
0.820	± 0.010	0.826	✓			
1.476	± 0.010	1.474	✓			
0.542	± 0.010	0.336/0.349	✓			
1.56	± 0.030	1.564	✓			
0.875	± 0.010	0.872	✓			
0.965	± 0.010	0.968	✓			
R 0.125	± 0.010	0.125	✓			
0.354	± 0.010	0.352	✓			
$\phi 0.166$	± 0.005 -0.001	0.168	✓			
0.147	± 0.010	0.139	✓			
0.717	± 0.010	0.718	✓			
0.697	± 0.010	0.691	✓			
0.229	± 0.010	0.231	✓			
R 0.125	± 0.010	0.125	✓			
R 0.063	± 0.010	0.063	✓			
0.063	± 0.010	0.067	✓			
0.126	± 0.010	0.127	✓			
0.630	± 0.010	0.629	✓			

Measured by: <i>S</i>	Audited by: <i>J.L</i>	Prototype Approval: <i>u/a</i>
Date: <i>06/11/12</i>	Date: <i>06/11/13</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	